

Work Order ID 143693

143693

Page 1

Monday, March 21, 2016 1:50:49 PM

Item ID: D2232-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Hinge
 Start Date: 3/21/2016 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 3/31/2016 Req'd Qty: 15.00 ***15*** Customer:
 Reference: DAS
 13

Approvals: Process Plan: 9-89 Date: MAR 21 2016 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2232	Rev C								

105 0.00 DAS
105 15 MAR 21 2016 13
 Purchasing Memo 9-89
 Purchasing ISSUE PO 31764
 CUT PER DRWG D2232 REV. C
 107 waterjet - open holes to size
 115 Receive & Inspect for Damage & Mat'l Certs 0.00
115 15x SP 16-04-01
 Packaging Memo 0.00
 Packaging
 125 QC5- Inspect part completeness to step on W/O 0.00
125 (15) DAS
 QC Memo 0.00 38
 Quality Control 9-89
 APR 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 143693

Monday, March 21, 2016 1:50:49 PM

143693

Page 2

Item ID: D2232-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Hinge

Start Date: 3/21/2016 Start Qty: 15.00

15

Cust Item ID:

Required Date: 3/31/2016 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								
	<i>v/A DAS 38 9-89</i>								
140	Identify as per dwg & Stock Location: _____	0.00							
140									
Packaging	Memo	0.00							
Packaging	*****STOCK IN BASKET CELL***** LOCATION: WA004								
	<i>15</i>								
	<i>DAS 8 9-89</i>								
	<i>APR 05 2016</i>								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.03							
Quality Control									
	<i>MLJ</i>								
	<i>APR 06 2016</i>								
	<i>MLJ</i>								
	<i>APR 06 2016</i>								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Picklist Print

Monday, March 21, 2016 1:50:48 PM

Page 1

Work Order ID: 143693

143693

Parent Item: D2232-3

D2232-3

Parent Item Name: Basket Hinge

Start Date: 3/21/2016

Required Date: 3/31/2016

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP B01.06.07Now laser cutEC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2232-3P		Purchased	No				Each	0.0000		15			
D2232-3P									**				
Basket Hinge													
M304S11GA		Purchased	No			100	sf	121.7250	0.0694	1.095789			
M304S11GA									**				
304/316 0.125 Sheet													

Location

Loc Qty

Loc Code

MAT020

121.72498

M129545

24.82498

M129972

21.7

M134284

75.2

M134604

15X
DAS
13
9-89

APR 01 2016

15-04-01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

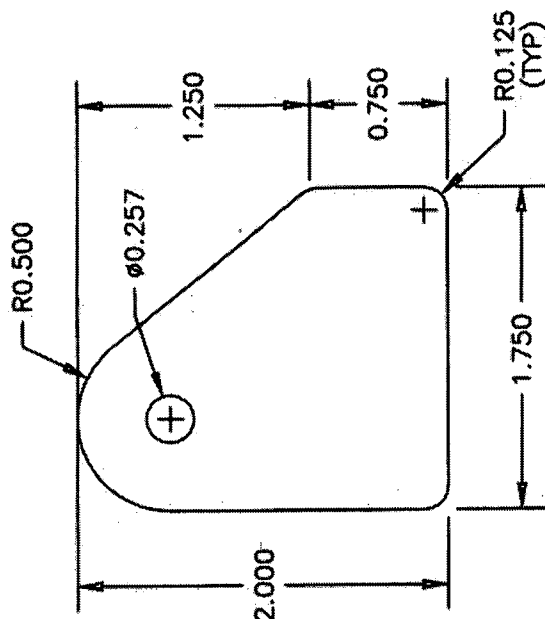
Work Order update only ☐

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		OTHER : ☐							



DESIGN	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>WJ</i>	APPROVED <i>KE</i>	DRAWING NO. D2232	REV. C SHEET 1 OF 2
DATE 98.04.28		TITLE BASKET HINGE	SCALE 1:1
A	94.05.12	NEW ISSUE	
B	96.01.02	ADDED -5 AND -7	
C	98.04.28	0.125 THICK WAS 0.063	

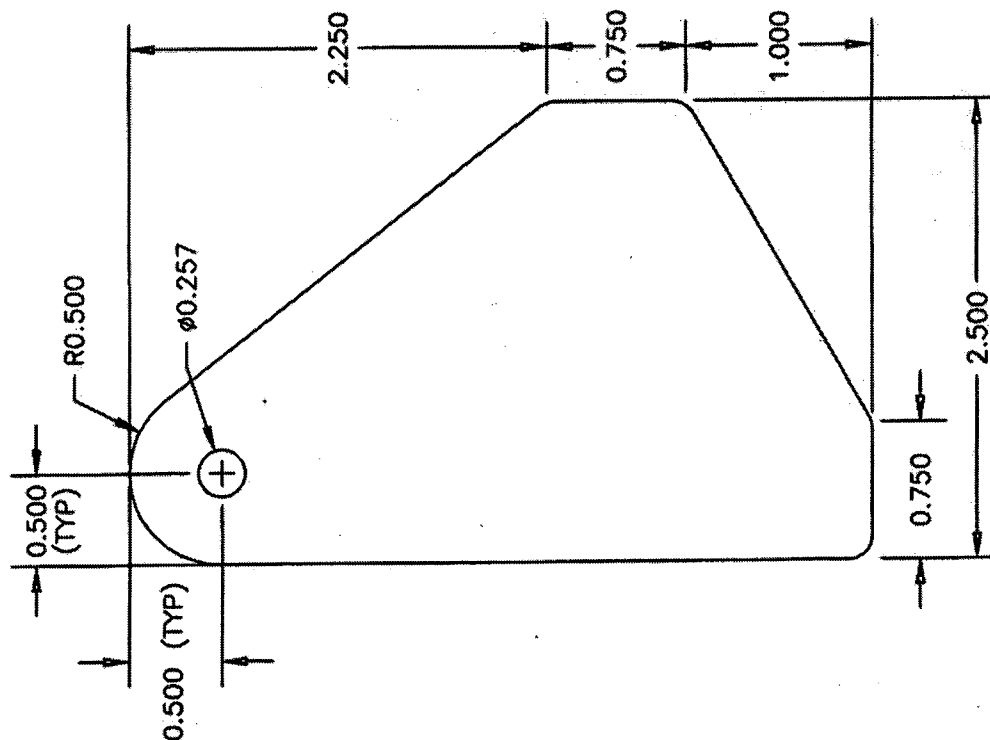
RELEASED
98.05.05 KE



D2232-1

DAS
13
9-89
MAR 9 1 51A

W10:143693



D2232-3

MATERIAL: AISI 304/316 SS 0.125 THICK

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

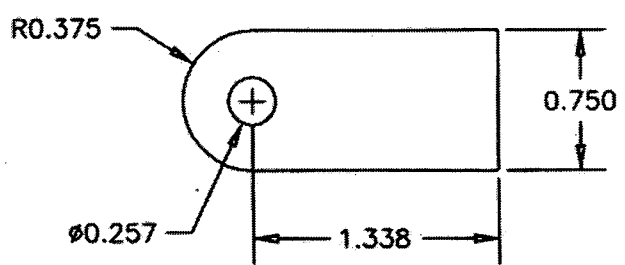
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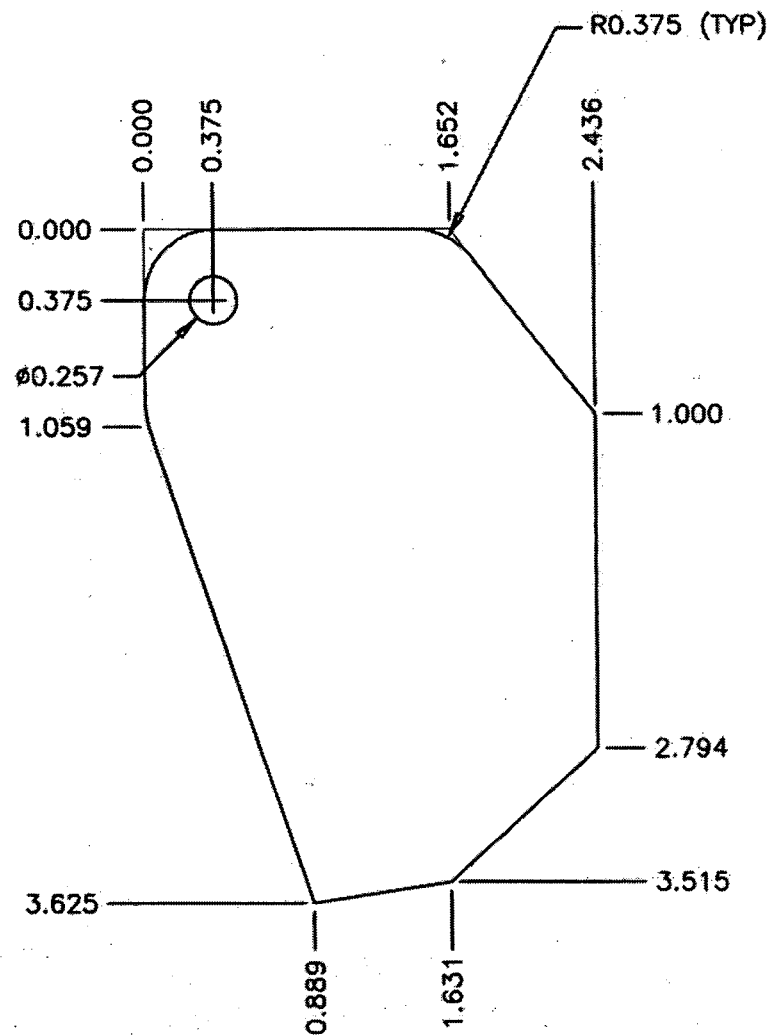


DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. C
CHECKED	APPROVED	DRAWING NO. D2232	SHEET 2 OF 2
DATE	TITLE	BASKET HINGE	SCALE
98.04.28			1:1

RELEASED
49.05.05 KE



D2232-7



D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		OTHER : ☐							

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 7436
Date: 2016-03-29
Page: 1

Sold to:

Dart Aerospace

Chantal Lavoie
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace
Chantal Lavoie
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7
Canada

Order No.: 31764

Sold By: JONATHAN LESSARD

Shipped By:

Ship Date: 2016-03-30

Tracking No.:

Item No	Unit	Description	Quantity
D2281 ✓		jack saddle ✓	80 ✓
D2585 ✓		latch clamp ✓	65 ✓
D3637-041 ✓		bracket assy ✓	12 ✓
D4060-1 ✓		ski clamp ✓	132 ✓
D4176-1 ✓		429 clamp ✓	8 ✓
d2232-3 ✓	Chaque	d2232-3 basket hinge ✓	15 ✓
d2581 ✓		mounting bracket ✓	68 ✓
D3191-1 ✓		fitting ✓	10 ✓
D3405-041 ✓		ground handling lug ✓	32 ✓
D3405-043 ✓		ground handling lug ✓	6 ✓
d3561-1 ✓	Chaque	d3561-1 seal insert tool ✓	6 ✓
d3912-5 ✓	Chaque	d3912-5 eyebolt plate ✓	30 ✓
d4021-1 ✓	Chaque	d4021-1 handle plate ✓	14 ✓
d4148-1 ✓	Chaque	d4148-1 crosstube lug plate fwd ✓	44 ✓
d4149-1 ✓	Chaque	d4149-1 crosstube lug plate aft ✓	20 ✓
d4150-3 ✓	Chaque	d4150-3 arm plate ✓	8 ✓
d4151-1 ✓	Chaque	d4151-1 lower hardpoint plate ✓	40 ✓
d4151-3 ✓	Chaque	d4151-3 upper hardpoint plate ✓	42 ✓

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days

SP/b-a-d



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31764**

Purchase Order Date 3/21/2016

PO Print Date 3/21/2016

Page Number 10 of 11

Order From :

VC-TPI001

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-633-0484

Ship To Contact

Ship To Phone

Ship Via: —

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total: **\$238.00**

24 D4151-3P

Upper Hardpoint Plate

4/6/2016

FN

12.00

\$6.00

\$72.00

Yes

4/6/2016

Each
rec'd 42

CUT AS PER DWG D4151 REV. C
B141612 X 30 PCS
B143354 X 12 PCS
MATERIAL 304 SHEET 11 GA

Line Total: **\$72.00**

25 D2232-3P

Basket Hinge

4/6/2016

FN

15.00

\$3.95

\$59.25

Yes

4/6/2016

Each
SP 16 04-01

CUT AS PER DWG D2232 REV. C
B143693
MATERIAL 304 SHEET 11 GA

Line Total: **\$59.25**

Note:

3/21/2016

THYSSENKRUPP MATERIALS NA

DART AEROSPACE

STAINLESS STEEL SHEET 304L-2B DUAL GRADE
 .1200 Nom X 48.0000" X 96.0000"
 PART NO.

PO/Rel 31741

We certify that this is a true copy of the report
 furnished by the producer of the metal, or data
 resulting from tests made in approved labs.

Certificate of Mill Test Results

BL PEC-983229-002

21Mar16

Pg 1/1



METALLURGICAL TEST REPORT

North American Stainless Canada Inc.
 740 Imperial Road North
 Guelph, ON N1K1Z3
 Canada

740 Imperial Road North

Certificate: 117938 1

Customer: 007206 001

Mail To:

THYSSENKRUPP MATERIALS
 2821 LANGSTAFF ROAD
 CONCORD, ON L4K5C6

Ship To:

THYSSENKRUPP MATERIALS
 2821 LANGSTAFF ROAD
 CONCORD, ON L4K5C6

Date: 11/26/2015 Page: 1

Steel: 304/304L

Finish: 2B

Corrosion: ASTM A262/14;180Bend-OK

Your Order: PEC271093

NAS Order: WN 0072789 07

PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, C.R. ANNEALED & PICKLED. UNS 30400/30403
 ASTM A240/15a,A480/14b,A666/15;ASME SA240/13,SA480/13,SA666/13
 CHEM ONLY ON FOLLOWING ASTM: A276/13,A479/13a,A484/13a,A312/13
 CHEM ONLY ON FOLLOWING ASME: SA312/13,SA479/13
 AMS 5511H/5513J XMRK; MIL-5059D AMD3(X CRN MEAS); MIL-4043B
 NACE MR0175/ISO 15156-3:2009 A, MR0103/07;Q95766D-A X MAG PERM
 MIN. SOLUTION ANNEAL TEMP 1900F, WATER QUENCHED

REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.
 EN 10204:2004 3.1; RoHS 1 & 2 Compliant
 Material is Free of Radioactive Contamination
 Steel Making Process: EAF, AOD, & Cont. Casting
 Product Mfg.by a Quality Mgt.Sys. in Conf. w/ISO 9001
 *Melted & Manufactured in the USA; Mat'l is DFARS Compliant

Product Id	Coil #	Skid #	Thickness	Width	Weight	Length	Mark	Pieces	Commodity Code
02X2A3 DA	02X2A3 D		.1163	48.0000	4,970	SHEETS	096.00	32	

Lab Accreditation Bureau, ISO/IEC 17025, Certificate# L2323

CHEMICAL ANALYSIS

CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan)

Chemical Analysis per ASTM A751/08

HEAT	CM	C %	CR %	CU %	MN %	MO %	N %	NI %	P %	S %
X2A3	US	.0270	18.2380	.3950	1.7650	.3735	.0830	8.0045	.0340	.0010
		SI %								
		.2375								

MECHANICAL PROPERTIES

Product Id#	Coil #	UTS	20C .2% YS	20C ELONG	% Hard	Tail
		KSI	KSI	%-2"	RB	Hard
02X2A3 DA	02X2A3 D	F T	92.66	44.92	51.32	86.00
						87.00

NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy
 of the test methods used, the material meets the specifications stated. These results relate only to the items
 listed and this report cannot be reproduced, except in its entirety, without the written approval of NAS.

Technical
 Dept. Mgr.

ABHJEET BHAVE

ABHJEET BHAVE

11/26/2015

STAINLESS STEEL SHEET 304L-2B DUAL GRADE
.0750 Nom X 48.0000" X 120.0000"
PART NO.

We certify that this is a true copy of the report furnished by the producer of the metal, or data resulting from tests made in approved labs.

Pg 1/1

Signed by:



No.600,Xinglong St., Jixing Vill., Gangshan Dist.,
Kaohsiung City 82057, Taiwan (R.O.C)

Specification/Steel Grade : DIN EN 10028-7 1.4301/1.4307_C
Surface Finish : No. 2B

1. We hereby certify that material described herein has been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification.
2. The material described above has been detected with free irradiation.
3. VUSON has established a QMS according to ISO 9001 which is certified by DNY CERT (reg.-no.0058-2002-XQ-PGC-KT1)
4. Inspection and gauge measurement: Satisfactory
5. The report can only be reproduced in full.
6. This certificate complies to 3.1/DIN EN 10204:2005.
7. The tests including "Tensile Test", "Intergranular Attack" (I.A. TEST) have been accredited by A2LA TESTING CERT #0958.02).

Manager of Quality Assurance Department

F. A. Hanson

JA-A-91